

Work Order ID 47805

June 26, 2009 12:28:14 PM

**PRELIMINARY ISSUE**

Page 1

Item ID: D3683-3

Revision ID: PRELIM

Item Name: Insert

Start Date: 30/07/2009 Start Qty: 30.00

Required Date: 03/08/2009 Req'd Qty: 30.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Purchasing

Memo

0.00

Purchasing



Date: Thursday, 07/05/2009 3:52:20 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INSERT
Job Number : 47805	
Estimate Number : 13903	
P.O. Number :	Part Number : D36833
This Issue : 07/05/2009 S.O. No. :	Drawing Number : D3683 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : PURCHASED PARTS	Drawing Revision : PRELIM
Previous Run :	Material :
Written By :	Due Date : 14/05/2009 Qty: ⁶⁵⁹ 30 Um: Each
Checked & Approved By : <u>UMF 09-05-07</u>	
Comment : Est Rev:A 09-04-30 new issue DD verified by:	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 2001853 /

Purchase Part Number: ALS7-428-165 or ALS4-428-165 (see dwg for additional equivalent)

Manufacturer: Avibank MFG inc. or Atlas Engineering or Spaenaur inc.

Supplier: Interfast

Certificate of conformity is required

2.0	ALS4428165	Inserts
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)
 Inserts

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

ENGINEERING
 APPROVAL



5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: 123

9/4/10

659 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 3:52:20 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSERT

Job Number: 47805

Part Number: D36833

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/09/01 *[Signature]*

Job Completion



mf 09-06-19

POSITIVE RECALL

EFFECTIVED *07-09-08* AUTH *[Signature]*

RELEASED *[Signature]* DATE *07/06/16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

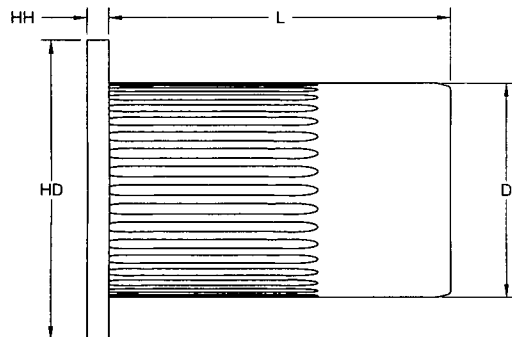
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

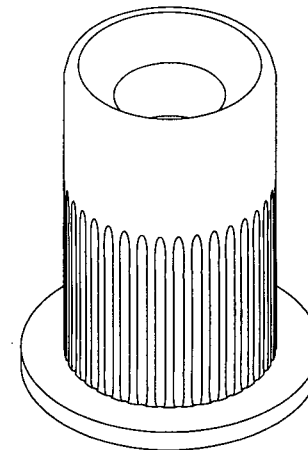
NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



D3683-X INSERT

PRELIMINARY ISSUE
Weg/26/19



DART P/N	THREAD SIZE	"D" MAX	"HD" ±0.015	"HH"	"L" ±0.015	POSSIBLE SUPPLIERS
D3683-1	#10-32	Ø0.296	Ø0.415	0.030	0.475	AVIBANK MFG INC P/N: ALS7-1032-130 ALS4-1032-130 AKS7-1032-130 AKS4-1032-130 ATLAS ENGINEERING: AELS-1032-130 SPAENAU INC: 215-074
D3683-3	1/4-28	Ø0.390	Ø0.500	0.030	0.580	AVIBANK MFG INC P/N: ALS7-428-165 ALS4-428-165 AKS7-428-165 AKS4-428-165 ATLAS ENGINEERING: AELS-428-165 SPAENAU INC: 215-076

NOTES:

- 1) MATERIAL: C-1010 OR C-1008 STEEL
- 2) FINISH: CAD PLATED PER QQ-P-416 TYPE II (GOLD) CLASS 2 WITH CLEAR PROTECTIVE COATING OR ZINC YELLOW PLATED PER ASTM-B633, FE/ZN 8, TYPE II WITH CLEAR PROTECTIVE COATING (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) THREADS: UNIFIED, CLASS 2B PER ASME B1.1
- 9) A CERTIFICATE OF CONFORMITY IS REQUIRED FROM THE MANUFACTURER TO VERIFY MATERIAL, FINISH, AND THREADS ARE PER THIS DWG

B	ADDED P/N D3683-3	RF	09.03.30
A	NEW ISSUE	DC	07.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	D4	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	E	D3683	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	#	INSERT	NTS
DATE	09.03.30	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Receiving Report

Date: 99.10.29
 Supplier: Rovets Unlimited

Batch No: M6989
 Dart P/O: 2001853

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☐ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒
 Shipment Complete: Yes ☒ No ☐

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

TSR No. _____

Production/Admin: 99/11/01
 Date: 2.1.853
 Received/Costing: ss
 Initial: _____

Initials of receiver (if shipment OK) REV A

Accounting: _____
 Date: _____
 AP/MR: _____
 Initial: _____

m:\admin\product\recslip

Total Value of Purchase Order

-GST Not in Price B-GST Included in Price C-GST Exempt
 -GST at Zero Percent I-Charge PST E-Not Charged PST

Kristina Young

333.65

Nov. 99

5175 RUE SAINT-JACQUES MONTRÉAL, Q.C.
H3T 1A4
VILLAGE SAINT-JACQUES, BOUTIQUE
441-1811



ADHÉSIFS • ADHESIVES

MACHINERIES

TEL: (514) 446-3596 TEL: (514) 622-2320 TEL: (440) 526-1976 TEL: (204) 582-0480 TEL: (314) 337-7534 TEL: (418) 877-3300 TEL: (314) 209-0075 TEL: (905) 405-9346 TEL: (604) 207-9699
FAX: (514) 446-3597 FAX: (514) 622-3193 FAX: (440) 526-1862 FAX: (204) 582-2942 FAX: (514) 745-2969 FAX: (418) 877-3634 FAX: (314) 209-0325 FAX: (905) 405-9352 FAX: (504) 207-9799

A/TO: EXPÉDIÉ À / SHIP TO:

DAVE AEROSPACE LTD
1270 AEROSPACE STREET

DAVE AEROSPACE LTD
1270 AEROSPACE STREET

515-6

HAVERHILL, ON
K6A 1K7

RECEIVED NOV 03 1999

HAVERHILL, ON
K6A 1K7

FACTURE • INVOICE

CLIENT / CUST. N° VENDOR / SALESM. N° COMM. CLIENT / CUSTOMER P.O. N° NOTRE N° DE COMM. / OUR ORDER N° T.V.O. / P.S.T. N° ENR. T.P.S. / G.S.T. REG. N°
045816 16 2001853 35816 EXEMPT No 9070855011
EXPÉDIÉ PAR / SHIP VIA F.A.B. / P.O.B. DATE DUE / DUE DATE TERMES / TERMS PRÉP. PAR / PREPARED BY DATE HEURE / TIME PAGE
COLLECT DUE WAREHOUSE NET 30 JOURS 01 29/10/1999 11:50 361

PRODUIT / PRODUCT N°	DESCRIPTION	LOT N°	COMM. / ORD.	B.O.	EXP. / SHIP.	U.M.	PRIX UNIT. PRICE	MONTANT / AMOUNT
44A-450-10-02	STEEL OPEN END INSERT 1.4-28					1X	330.480	330.48
	C OF 5 REQUIS							
	DROP SHIP TORONTO							
<p>1992466455140401 PAIEMENT 2370 Paulus st. R103298534 Village St-Laurent, Brossard 445 (81)</p>								

CONDITIONS:

03/10/1999
5:21
MARTINA
613-632-3336

SOUS-TOTAL	330.48
SUB-TOTAL	
T.P.S.	53.31
G.S.T.	
T.V.O.	0.49
P.S.T.	
TOTAL	384.28

CLIENT - CUSTOMER

7. N8 CHRISTIAN.

*RIVETS UNLIMITED MONTREAL INC
2670 PAULUS
ST LAURENT, QC
H4S 1G1*

CERTIFICATE OF CONFORMANCE

Your PO:95020033522

Our Order #:...92400186150

Shipping Date:October 28 1999

Product Name & Number:...ALS4-428-165

Your Part #:...

Batch / Lot Number 9992192

Quantity:...1M


Expiration Date:...Indefinite

The parts covered by this certificate have been manufactured against your purchase order to meet the specification requirements and/or any deviations called for by the drawing which our records show effective at the time of manufacture. Only raw materials certified by the producing mills have been used for manufacture of these parts and these records are on file and available for examination upon request.

Yours truly,

Rivets Unlimited Toronto Inc.

905-612-9220


N Mistry

Customer Service Operations

PURCHASE ORDER

Dart Aerospace Ltd.

PO Number: 2004252
Date: 10-05-99
Account #: **FAKED**

Vendor:
Rivets Unlimited
2670 PAULUS
VILLE ST. LAURENT, QUE
CANADA, H4S 1G1

Sold To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont
Canada, K6A 1K7

Ship To:
S A M E

Attn : Christian
Vendor Tel : (514) 337-7534
Vendor Fax : (514) 745-2969

Purchaser : KRISTINA YOUNG
Telephone : (613) 632-3336
Fax : (613) 632-4443

Ship Via : LOOMIS
FOB Point : ORIGIN
Freight Chgs : Collect
GST# : RT101272607
PST# : 6122-5207
OE# :
Comments: Material certification is required upon delivery

Line	Ordered	Manuf	Manufacturer	Part No	Our Part Number	Part Description	Delivery	Unit Cost	Extended
1	✓	1000.00		ALS4-428-165		Inserts	10-11-99	0.3337/U	333.65 AE

Notes: Material certification is required.

Please ship ASAP. Loomis acct # GX 8357

Total Value of Purchase Order

Kristina Young

A-GST Not in Price
D-GST at Zero Percent
B-GST Included in Price
I-Charge PST
C-GST Exempt
E-Not Charged PST

333.65

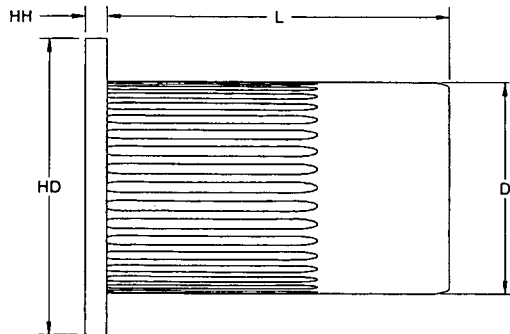
Nov. 99

RECEIVING REGISTER

Page 332

BATCH	DATE	SHIPPED FROM	DESCRIPTION/ PART NO.	PACKING SLIP	PURCHASE ORDER	CARRIER	WAYBILL	RELEASE BY	NOTE
M	6984	11/10/91	From the station	Managers Office	201113	United	—	N.A.	SB
M	6985	11/10/91	Ac Blards	Black Print Marker	1117049093	United	—	N.A.	SB
M	6986	11/10/91	Wm. Neilsen	Some type Brown	2343763	United	—	N.A.	SB
M	6987	11/10/91	Cutter	3 in. Gun Roping	40144222	United	11/10/91	N.A.	SB
M	6988	11/10/91	Some Hardware	Sample	201113	United	11/10/91	N.A.	SB
M	6989	11/10/91	Kinet Unlimited	AT54-455 TC5	92400156150	UPS	11/10/91	N.A.	SB
M	6990	11/11/91	LA Inc	Highway Coll.	014-11-0361	United	—	N.A.	SB
M	6991	11/11/91	Wild P.B. Inc.	Pat. on a Paper	011352	United	11/11/91	N.A.	SB
M	6992	11/11/91	George Kanick	2000 60116 Tuxedo	01007015	United	—	N.A.	SB
M	6993	11/11/91	George Kanick	2000 60116 Tuxedo	01007015	United	—	N.A.	SB
M	6994	11/11/91	RLD	Black Paper, 100 Sheets	00390	United	—	N.A.	SB
M	6995	11/11/91	Wild P.B. Inc.	2000 60116 Tuxedo	01007015	United	—	N.A.	SB
M	6996	11/11/91	Wild P.B. Inc.	2000 60116 Tuxedo	01007015	United	—	N.A.	SB
M	6997	11/11/91	Wild P.B. Inc.	2000 60116 Tuxedo	01007015	United	—	N.A.	SB
M	6998	11/11/91	Home Hardware	Some type Brown	2343763	United	—	N.A.	SB
M	6999	11/11/91	For KA-XIT 514	Recessed	—	United	11/11/91	N.A.	SB
M	7000	11/11/91	Alpine Dewtech	3 cross tubes 2 Skutumpah	—	United	11/11/91	N.A.	SB
M	7001	11/11/91	Home Hardware	Some type Brown	2343763	United	—	N.A.	SB
M	7002	11/11/91	Home Hardware	Some type Brown	2343763	United	—	N.A.	SB
M	7003	11/11/91	Home Hardware	Some type Brown	2343763	United	—	N.A.	SB
M	7004	11/11/91	Home Hardware	Some type Brown	2343763	United	—	N.A.	SB
M	7005	11/11/91	Home Hardware	Some type Brown	2343763	United	—	N.A.	SB
M	7006	11/11/91	RLD	Black Paper, 100 Sheets	00390	United	—	N.A.	SB
M	7007	11/11/91	RLD	Black Paper, 100 Sheets	00390	United	—	N.A.	SB
M	7008	11/11/91	Home Hardware	Some type Brown	2343763	United	—	N.A.	SB
M	7009	11/11/91	Home Hardware	Some type Brown	2343763	United	—	N.A.	SB

SPECIFICATION CONTROL DRAWING

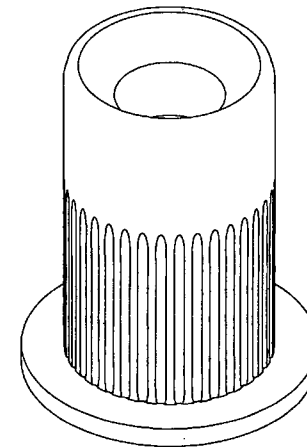


D3683-X INSERT

DART P/N	THREAD SIZE	"D" MAX	"HD" ±0.015	"HH"	"L" ±0.015	POSSIBLE SUPPLIERS
D3683-1	#10-32	Ø0.296	Ø0.415	0.030	0.475	AVIBANK MFG INC P/N: ALS7-1032-130 ALS4-1032-130 AKS7-1032-130 AKS4-1032-130 ATLAS ENGINEERING: AELS-1032-130 SPAENAU INC: 215-074
D3683-3	1/4-28	Ø0.390	Ø0.500	0.030	0.580	AVIBANK MFG INC P/N: ALS7-428-165 ALS4-428-165 AKS7-428-165 AKS4-428-165 ATLAS ENGINEERING: AELS-428-165 SPAENAU INC: 215-076

NOTES:

- 1) MATERIAL: C-1010 OR C-1008 STEEL
- 2) FINISH: CAD PLATED PER QQ-P-416 TYPE II (GOLD) CLASS 2 WITH CLEAR PROTECTIVE COATING OR ZINC YELLOW PLATED PER ASTM-B633, FE/ZN 8, TYPE II WITH CLEAR PROTECTIVE COATING (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) THREADS: UNIFIED, CLASS 2B PER ASME B1.1
- 9) A CERTIFICATE OF CONFORMITY IS REQUIRED FROM THE MANUFACTURER TO VERIFY MATERIAL, FINISH, AND THREADS ARE PER THIS DWG



47805

RELEASED
09/07/10

B	ADDED P/N D3683-3	RF	09.03.30
A	NEW ISSUE	DC	07.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	RF	D3683	SHEET 1 OF 1
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	INSERT	NTS
DE APPR.	RF	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	09.03.30		